

# Work Order ID 65812



Page 1

Wednesday, January 26, 2011 10:56:27 AM

Item ID: D3531-041

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

10

Stop



Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 1/26/2011

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3531	Rev A

100



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D3531

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

5.10.24

10

120



Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

m 112588.

Memo

130

OVEN TEMPERATURE:

0.00

START TIME:

300

FINISH TIME:

200

10 Bl 11-2-26

Powdercoat

Powder Coating

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 65812**

Page 2

Wednesday, January 26, 2011 10:56:27 AM

Item ID: D3531-041

Accept



Setup

Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInspec.  
Stamp

130



QC3- Inspect Part Finish

0.00

QC

Quality Control

140

Identify as per dwg & Stock Location: 228

0.00

Packaging

Packaging

Memo

0.00

150



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

Wednesday, January 26, 2011 10:56:32 AM

Work Order ID: 65812



Parent Item: D3531-041



Parent Item Name: Bracket Assembly

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3531-1 		Manufactured	No			100	Each	3.0000	1	4	 J511/02/23 B66235 (7x)		
Bracket							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				st238				3					
					64115			3					
D3531-3 		Manufactured	No			100	Each	2.0000	1	4	 J511/02/23 B66239 (9x)		
Bracket Front Plate							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				ST031				1					
					64116			1					
				ST068				1					
					61781			1					
MS20470AD4-4 		Purchased	No			100	Each	4,926.000	12	48	 J511/02/23 120		
Rivet, Universal Head							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				ST319				4926					
					112314			30					
					113368			92					
					116188			1168					
					116391			3636					

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			

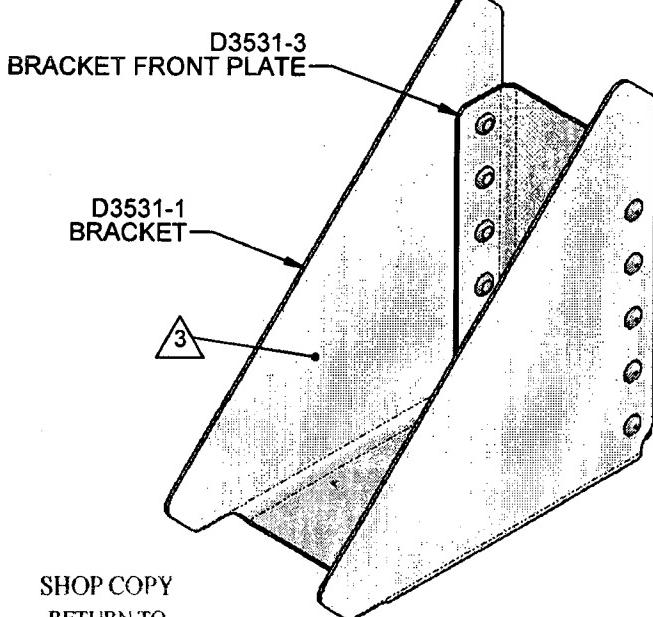
NOTE: Date &amp; initial all entries

**DART**

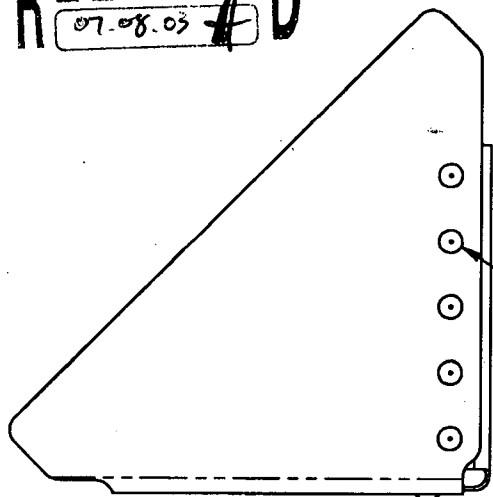
DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>JH</i>	DRAWING NO. D3531	REV. A	SHEET 1 OF 3
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SCALE 1:2	
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE		

4  
TRANSFER DRILL #9 ( $\phi$  0.196)

4  
TRANSFER DRILL #30 ( $\phi$  0.129)  
INSTALL MS20470AD4-4 RIVET  
(2 PLACES)

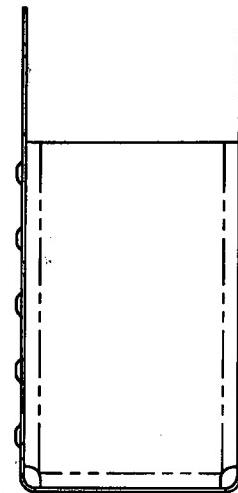


**RELEASED**  
07-08-03



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *63812*  
*04/11-01-26*

MS20470AD4-4  
(10 PLACES)



### D3531-041 BRACKET ASSEMBLY

#### NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK  
SANTEX (4.3.5.7) PER DART QSI 005 4.3  
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING  
WHITE MARKER ON INSIDE OF BRACKET  
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET  
THROUGH D3531-3 BRACKET FRONT PLATE  
BEFORE FINISHING

#### PARTS LIST

QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

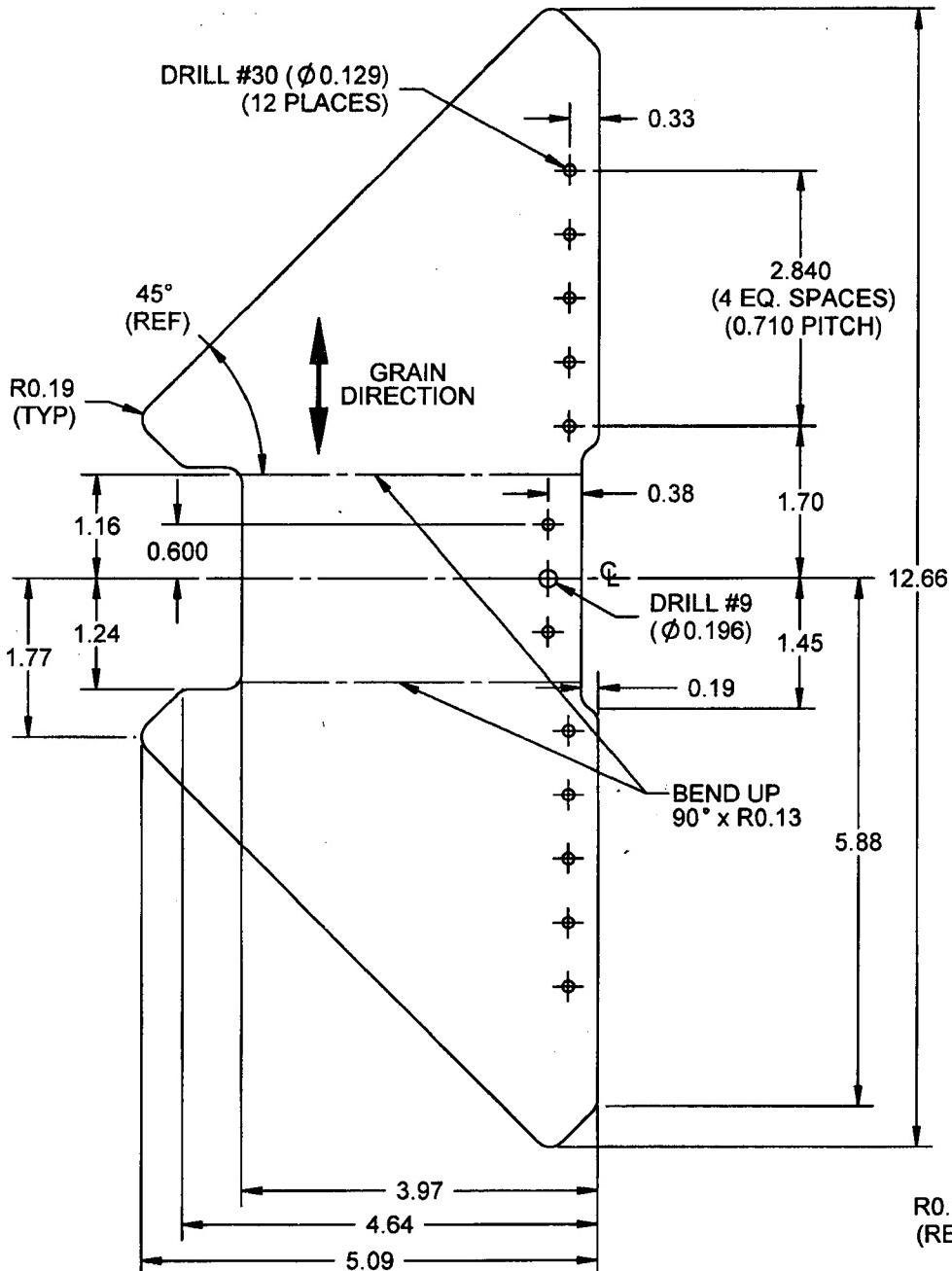
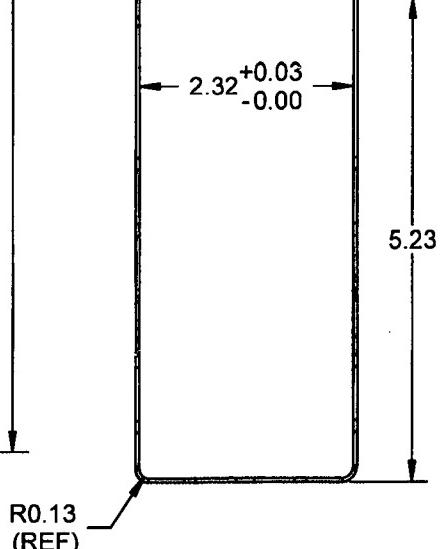
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NOTE: Date & initial all entries

**DART**

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>M</i>	DRAWING NO. D3531	REV. A SHEET 2 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY	SCALE 1:2	<i>wb63812</i>

**D3531-1F FLAT PATTERN****D3531-1 BRACKET****NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\frac{Q}{2}$

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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

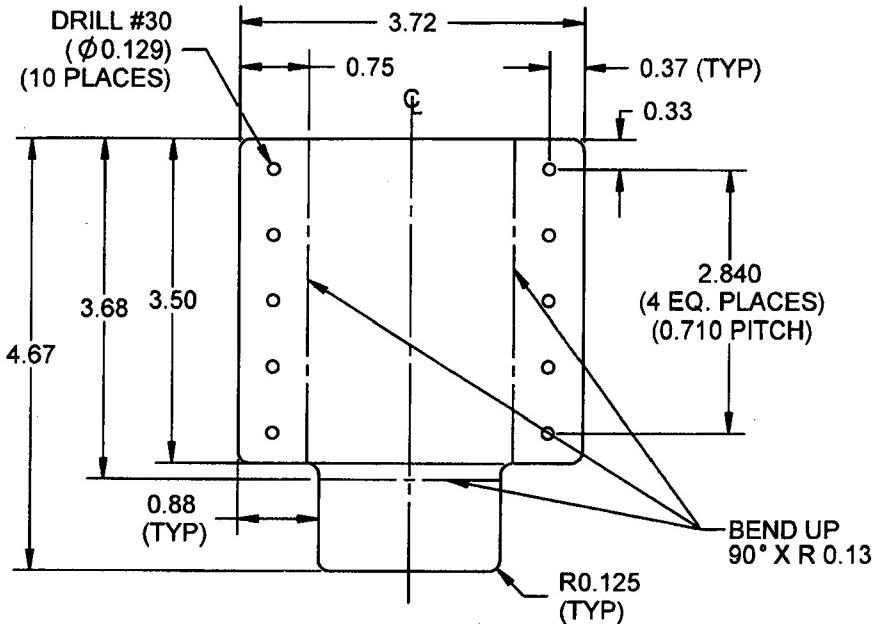
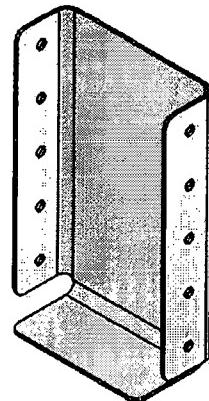
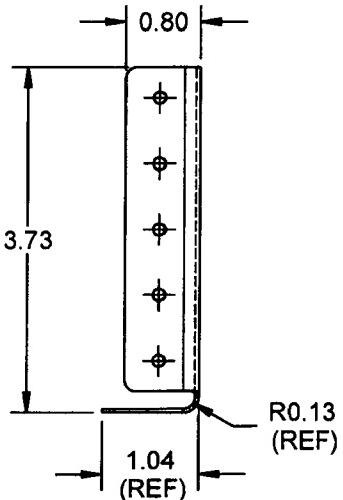
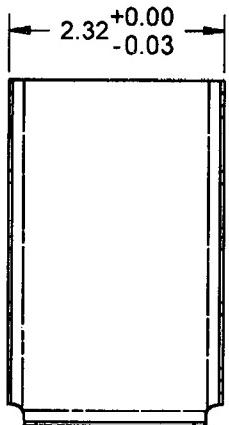
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NOTE: Date & initial all entries

**DART**

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>TH</i>	DRAWING NO. D3531	REV. A SHEET 3 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY	SCALE 1:2	

**RELEASED**  
07.08.03 *[Signature]**4065812***D3531-3 BRACKET FRONT PLATE****NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\varnothing$

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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